

Work Order ID 90576

90576

Page 1

September-20-12 7:50:05 AM

Item ID: D3849-1

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Plate

Start Date: 9/17/12 Start Qty: 12.00

12

Cust Item ID:

Required Date: 10/12/12 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12-09-12

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3849	D								

100 0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3849

Dwg Rev: 8

Prog Rev: 8

2-Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

124

0

Jan 12 9-30

131

0

Jan 12 9-30

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:25%;">Skid-tube <input type="checkbox"/></td> <td style="width:25%;">Crosstube <input type="checkbox"/></td> <td style="width:25%;">Water Jet <input type="checkbox"/></td> <td style="width:25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>																									
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector																		
Doc/Data <input type="checkbox"/>																											
Equip/Tooling <input type="checkbox"/>																											
Operator <input type="checkbox"/>																											
Material <input type="checkbox"/>																											
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Other <input type="checkbox"/>																											
Process <input type="checkbox"/>																											
Supplier <input type="checkbox"/>																											
Training <input type="checkbox"/>																											
Unapproved <input type="checkbox"/>																											

FAULT CATEGORY												
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other	

Work Order ID 90576***90576***

Page 2

September-20-12 7:50:05 AM

Item ID: D3849-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Plate

Start Date: 9/17/12 Start Qty: 12.00

12

Cust Item ID:

Required Date: 10/12/12 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

SMB
120.01

14

130

0.00

130

Brake NC

Memo

0.00

Brake NC

Form as per dwg using DT8179 & DT8155

14

SP
12/10/09

210

QC5- Inspect part completeness to step on W/O

0.00

210

QC

Memo

0.00

Quality Control

BAS
16

17/10/09

(14)

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:33%;">Skid-tube <input type="checkbox"/></td> <td style="width:33%;">Crosstube <input type="checkbox"/></td> <td style="width:33%;">Water Jet <input type="checkbox"/></td> <td style="width:33%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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FAULT CATEGORY												
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Work Order ID 90576***90576***

Page 3

September-20-12 7:50:05 AM

Item ID: D3849-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Plate

Start Date: 9/17/12 Start Qty: 12.00

12

Cust Item ID:

Required Date: 10/12/12 Req'd Qty: 12.00

12

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

220

Identify as per dwg & Stock Location: W/A

0.00

220

Packaging

Memo

0.00

Packaging

(x14) me 12-10-15

230

QC21- Final Inspection - Work Order Release

0.00

230

QC

Memo

0.00

Quality Control

MLJ 12-10-16MLJ 12-10-16

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width: 25%;">Skid-tube <input type="checkbox"/></td> <td style="width: 25%;">Crosstube <input type="checkbox"/></td> <td style="width: 25%;">Water Jet <input type="checkbox"/></td> <td style="width: 25%;">Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table>						Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coord. <input type="checkbox"/>	Quality <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>	
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Unapproved <input type="checkbox"/>																											

FAULT CATEGORY				
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Picklist Print

September-20-12 7:50:04 AM

Page 1

Work Order ID: 90576

Parent Item: D3849-1

Parent Item Name: Plate

Start Date: 9/17/12

Required Date: 10/12/12

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A NEW ISSUE 12-08-23 JLM VERIFIED BY:DD IPP Rev:B 12.09.11 AS PER
DWG REV.D DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA 304/316 .050 Sheet		Purchased	No			100	sf	148.9849	3.585	45.28421 460			Jm 12-9-30
				<u>Location</u>	<u>Loc Qty</u>		<u>Loc Code</u>						
				MAT020	148.984947								
				120604	4.38421								
				121626	1.65								
				121660	27.000737								
				122325	115.95								
				123155					123155				

NCR: Yes / No

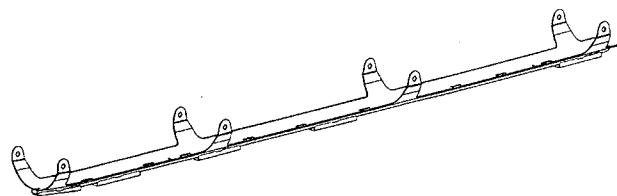
WORK ORDER NON-CONFORMANCE / UPDATE

DQA: _____ Date: _____

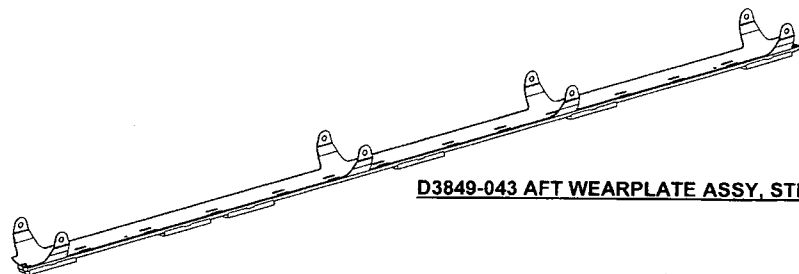
QA Closed: _____ Date: _____

Work Order: _____ Part No. _____ NCR No. _____				DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Work Order Update <input type="checkbox"/>		AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div>					
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector		
Doc/Data <input type="checkbox"/>											
Equip/Tooling <input type="checkbox"/>											
Operator <input type="checkbox"/>											
Material <input type="checkbox"/>											
Setup <input type="checkbox"/>											
Other <input type="checkbox"/>											
Process <input type="checkbox"/>											
Supplier <input type="checkbox"/>											
Training <input type="checkbox"/>											
Unapproved <input type="checkbox"/>											

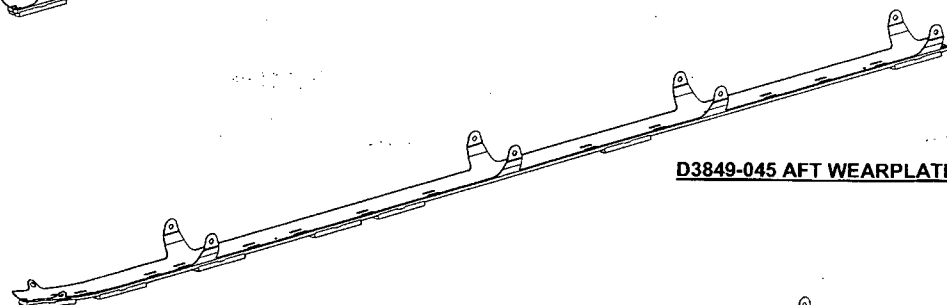
FAULT CATEGORY											
Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimped. <input type="checkbox"/> Cuffs <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Ripples in Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube			General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damaged <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drill Holes <input type="checkbox"/> Drawing <input type="checkbox"/> Finish <input type="checkbox"/> Folio			<input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Offset <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions			<input type="checkbox"/> Ovalized <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge		<input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other



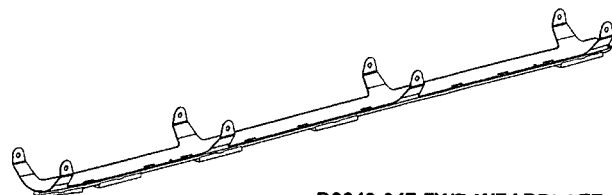
D3849-041 FWD WEARPLATE ASSY, STD GEAR



D3849-043 AFT WEARPLATE ASSY, STD GEAR



D3849-045 AFT WEARPLATE ASSY, FLOAT GEAR



D3849-047 FWD WEARPLATE ASSY, FLOAT GEAR

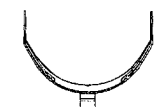
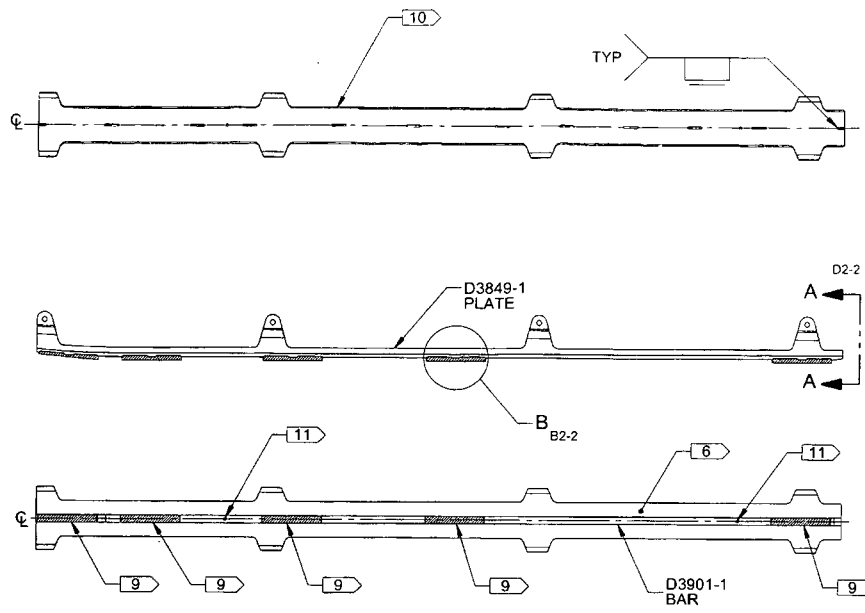
ITEM	QTY -041	QTY -043	QTY -045	QTY -047	P/N	DESCRIPTION
1	X				D3849-041	FWD WEARPLATE ASSY, STD GEAR
2		X			D3849-043	AFT WEARPLATE ASSY, STD GEAR
3			X		D3849-045	AFT WEARPLATE ASSY, FLOAT GEAR
4				X	D3849-047	FWD WEARPLATE ASSY, FLOAT GEAR
11	1				D3849-1	PLATE
12		1			D3849-3	PLATE
13			1		D3849-5	PLATE
14				1	D3849-7	PLATE
15	1			1	D3901-1	BAR
16		2			D3901-3	BAR
17			2		D3901-5	BAR
21	A/R	A/R	A/R	A/R	2059B	HARDCOAT
22	A/R	A/R	A/R	A/R	4714	PLUS ONE ROCKGUARD

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

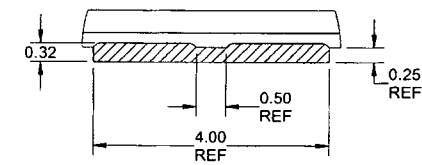
NO. 90576 MLJ
12-09-20
RELEASED
2012-09-04
JW

D	REVISED FLAT PATTERN - CHANGED SLOT LOCATIONS TO MATCH D3901-1/3/5 BARS (ZN B6-6, B3-6, B6-7, C2-7, B6-8, B2-8, B7-9, B2-9)	DC	12.08.23
C	REVISED FLAT PATTERN - CHANGE SLOT LOCATIONS, ADDED DOUBLE SLOTS AND D3901-3/5 BARS ON -043/-045. UPDATED DETAIL VIEWS. CHANGED WELD DETAILS (ZN B2-2). REMOVED D3848-1/3/5/7 GASKETS, ADD ROCKGUARD COATING, REMOVE FINISH.	DC	12.08.21
B	REVISED FLAT PATTERN Ø0.375 WAS SLOT HOLE ON D3849-1F/3F/5F (ZN A4-5, B4-7, B4-8, C2-10, B2-10); ADD D3849-047 (ZN D4-1, A4-1 & B4-5) & D3849-7/7F (ZN C4-9, A4-9); ADD SECTION K-K (ZN C5-10); 0.88 WAS 0.875 & 0.44 WAS 0.438 (ZN A3-10); ADD 0.25 & 0.88 (ZN D4-10, D3-10); ADD 0.88 & 0.44 (ZN C3-10 & B3-10); ADD FLAG NOTE (ZN A8-2, C6-2, C3-2, A8-3, C6-3, C3-3, A8-4, C6-4, C2-4); 66.87 WAS 67.36 (ZN B4-7)	RF	09.06.30
A	NEW ISSUE	RF	09.03.30
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	BC		
CHECKED	BC		
MFG. APPR.	BC		
APPROVED	BC		
DE APPR.	BC	DRAWING NO. D3849	
DATE	12.08.23	REV. D	
		SHEET 1 OF 10	
		SCALE	
		NTS	
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90576



SECTION A-A
C3-2



DETAIL B
C5-2

D3849-041 FWD WEARPLATE ASSY, STD/FLOAT GEAR

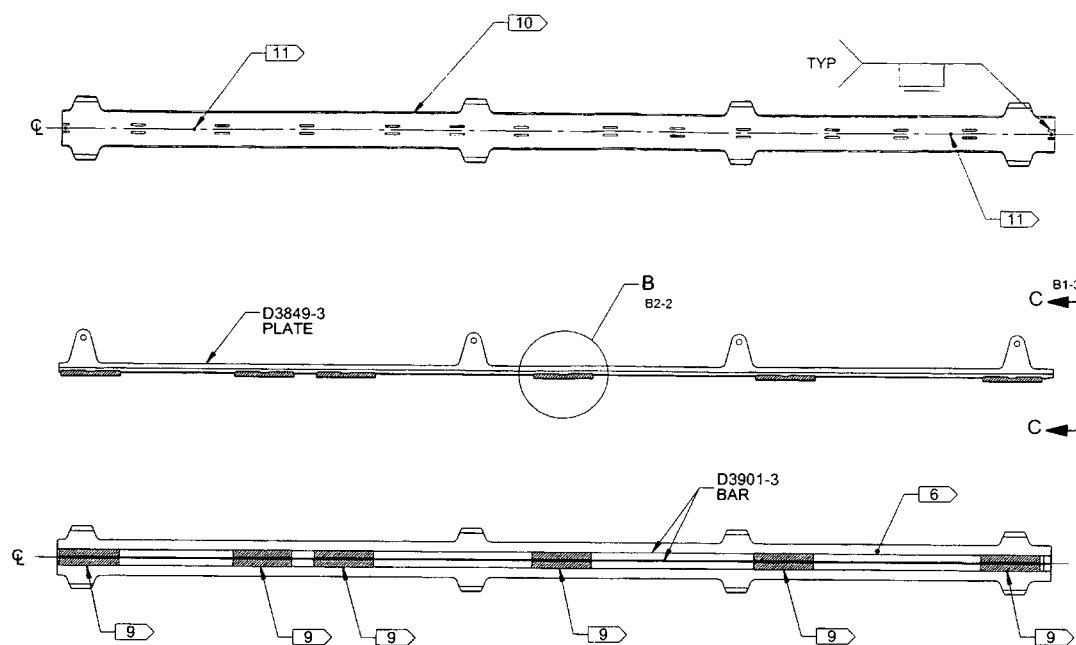
RELEASED
2012-09-04
mp

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 AS SHOWN
- 7) WEIGHT: D3849-041 = 4.58 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.32 THICK x 0.50 WIDE, FLUSH WITH D3901-1 BAR ON LATERAL SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 11) TRANSFER DRILL $\varnothing 0.188$ HOLES FROM D3849-1 PLATE TO D3901-1 BAR

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	BC	KENT, WA	
CHECKED	BE	DRAWING NO.	REV. D
MFG. APPR.	DE	D3849	SHEET 2 OF 10
APPROVED	MP	TITLE	SCALE
DE APPR.	DE	WEARPLATE ASSY	NTS
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90576



D3849-043 AFT WEARPLATE ASSY, STD GEAR

SECTION C-C

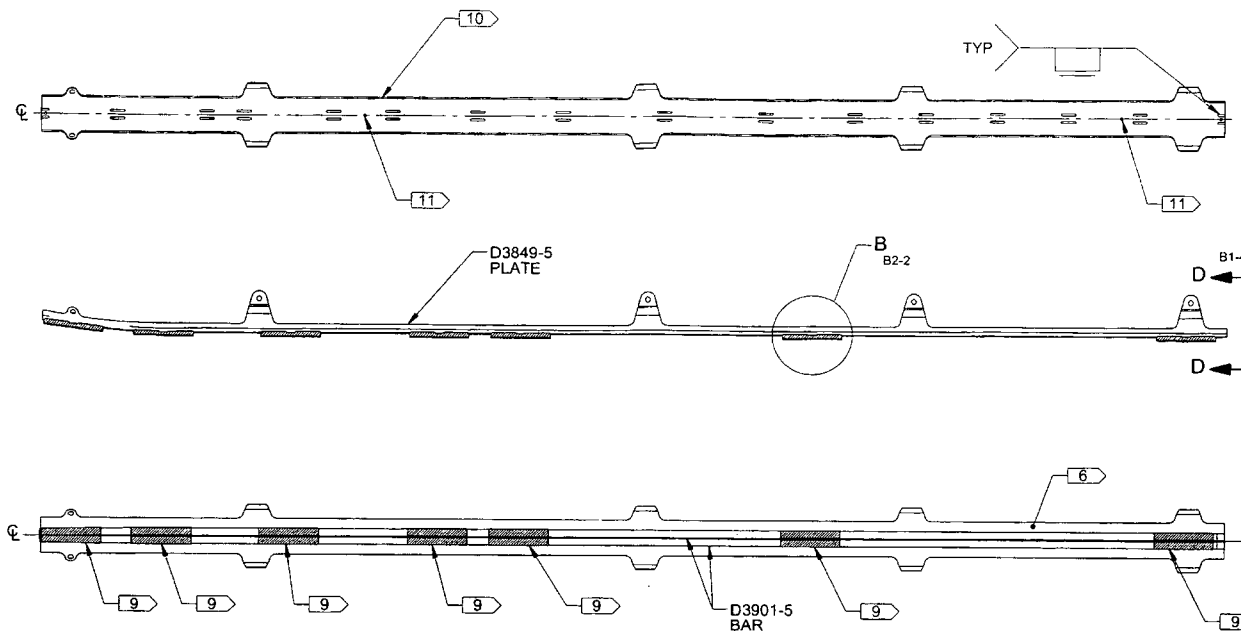
C3-3

RELEASED
2012-09-04

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 AS SHOWN
 - 7) WEIGHT: D3849-043 = 7.66 lbs
 - 8) WELDING: PER QSI 004
 - 9) 2059B HARDCOAT WELD, 0.32 THICK x 0.50 WIDE, FLUSH WITH D3901-3 BARS ON LATERAL SURFACES
 - 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD-4714, 0.020-0.040-THICK
 - 11) TRANSFER DRILL \varnothing 0.188 HOLES FROM D3849-3 PLATE TO D3901-3 BARS

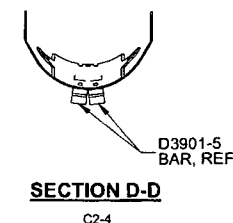
DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	BC		
CHECKED	BC	DRAWING NO. D3849	REV. D
MFG. APPR.	BC	SHEET 3 OF 10	
APPROVED	BC	TITLE WEARPLATE ASSY	SCALE NTS
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DATE	12.08.23		

9576



D3849-045 AFT WEARPLATE ASSY, FLOAT GEAR

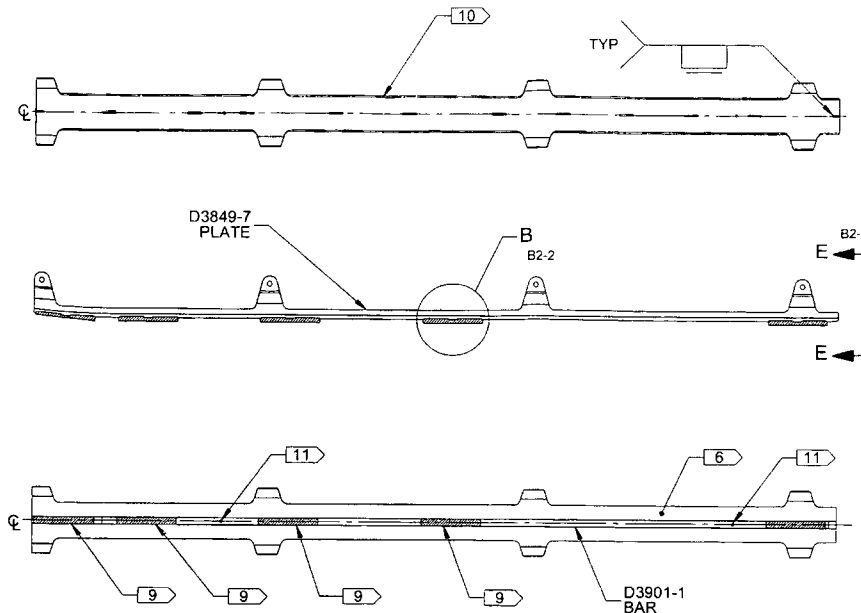
RELEASED
2012-09-04



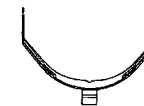
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 AS SHOWN
- 7) WEIGHT: D3849-045 = 8.93 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.32 THICK x 0.50 WIDE, FLUSH WITH D3849-5 BARS ON LATERAL SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 11) TRANSFER DRILL \varnothing 0.188 HOLES FROM D3849-5 PLATE TO D3901-5 BARS

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	BC	KENT, WA	
CHECKED	BC	DRAWING NO.	REV. D
MFG. APPR.	BC	D3849	SHEET 4 OF 10
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	WEARPLATE ASSY	NTS
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D3849-047 FWD WEARPLATE ASSY, FLOAT GEAR



SECTION E-E

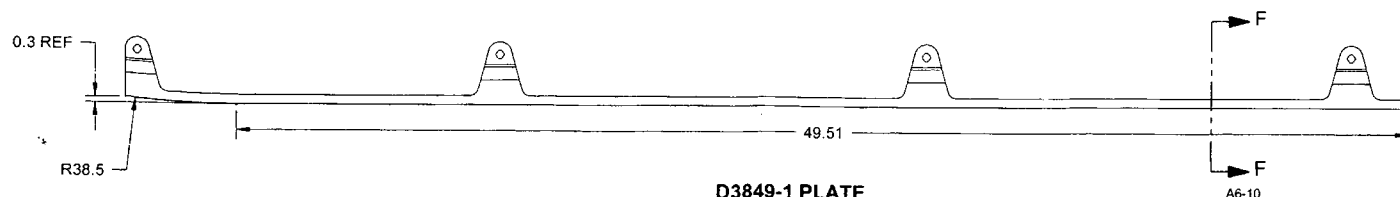
C3-5

RELEASED
2012-09-04

NOTES:

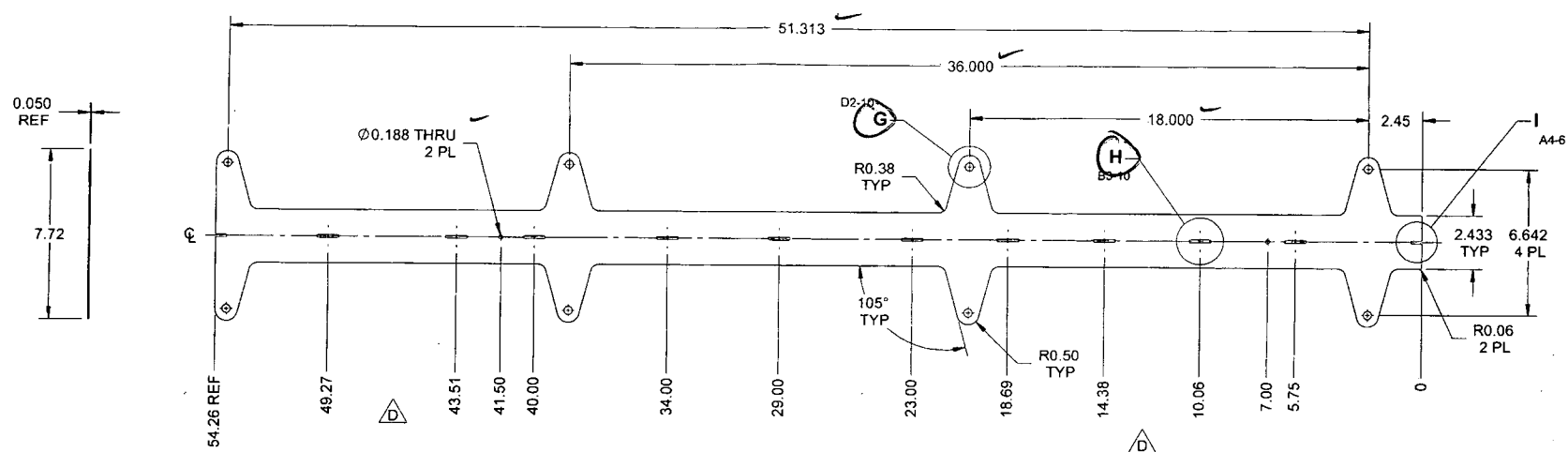
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1 AS SHOWN
- 7) WEIGHT: D3849-047 = 4.60 lbs
- 8) WELDING: PER QSI 004
- 9) 2059B HARDCOAT WELD, 0.32 THICK x 0.50 WIDE, FLUSH WITH D3901-1 BAR ON LATERAL SURFACES
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH A LAYER OF PLUS ONE ROCKGUARD 4714, 0.020-0.040 THICK
- 11) TRANSFER DRILL. $\phi 0.188$ HOLES FROM D3849-7 PLATE TO D3901-1 BAR

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	DC	KENT, WA	
CHECKED	AS	DRAWING NO.	REV. D
MFG. APPR.	DS	D3849	SHEET 5 OF 10
APPROVED	MP	TITLE	SCALE
DE APPR.		WEARPLATE ASSY	NTS
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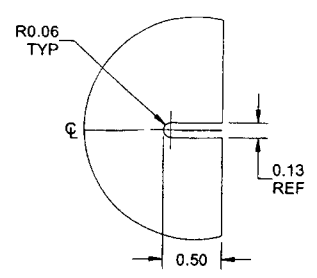


D3849-1 PLATE
(MAKE FROM D3849-1F)

90576



D3849-1F FLAT PATTERN



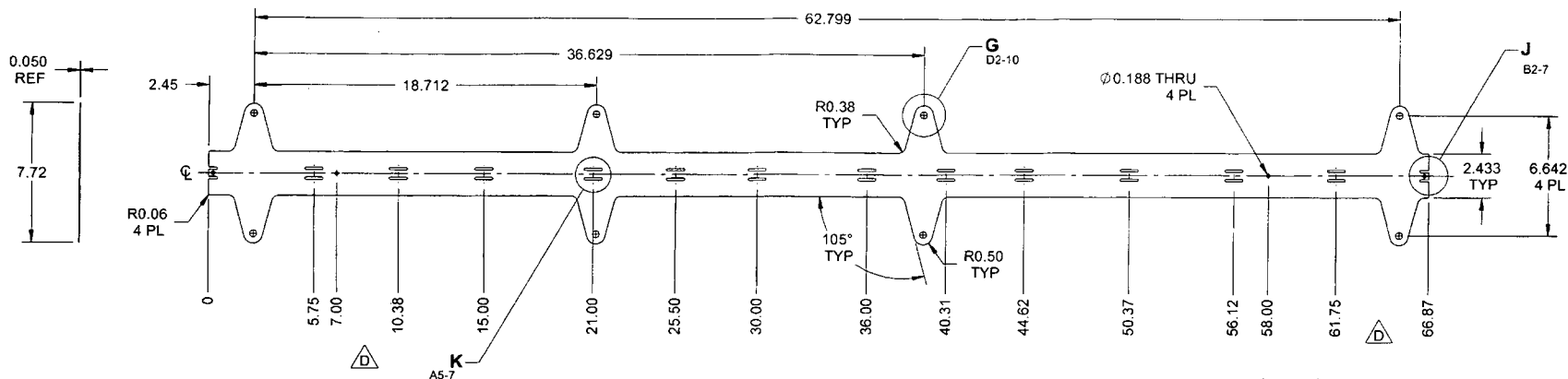
DETAIL I

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 2.30 lbs

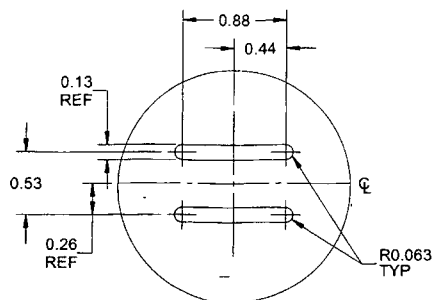
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2012-09-04

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	DC	KENT, WA	
CHECKED	AS	DRAWING NO. D3849	REV. D
MFG. APPR.	MS	SHEET 6 OF 10	
APPROVED	MS	TITLE	SCALE
DE APPR.	MS	WEARPLATE ASSY.	NTS
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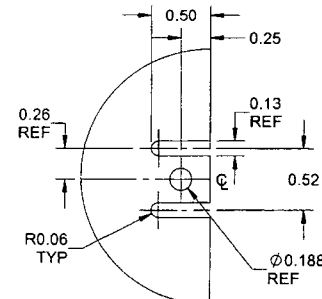
D3849-3 PLATE
(MAKE FROM D3849-3F)



D3849-3F FLAT PATTERN



DETAIL K



DETAIL J

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 2.74 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	DC	KENT, WA	
CHECKED	AS	DRAWING NO.	REV. D
MFG. APPR.	AS	D3849	SHEET 7 OF 10
APPROVED	AS	TITLE	SCALE
DE APPR.	AS	WEARPLATE ASSY	NTS
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2012-09-01

90576

0.050 REF

7.72

6.642 4 PL

2.433 TYP

2.45

18.712

36.622

75.261

62.788

A5-7 K

R0.38 TYP

D2-10 G

Ø0.188 THRU 4 PL

105° TYP

R0.50 TYP

0.75 TYP J B2-7

3.283

R0.38 2 PL L B2-10

0

5.75

7.00

10.56

15.38

20.19

25.00

31.00

37.81

44.63

50.38

56.11

60.11

66.11

68.61

74.63

79.76

D

RELEASED
2012-09-04
WNT

1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
OR ASTM A240 OR ASME SA240
18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)

2) FINISH: NONE

3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED

5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX

6) IDENTIFICATION: NONE

7) WEIGHT: 3.17 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	<i>BC</i>	KENT, WA	REV. D
CHECKED	<i>BC</i>	DRAWING NO. D3849	SHEET 8 OF 1
MFG. APPR.	<i>BC</i>	TITLE	SCALE
APPROVED	<i>BC</i>	WEARPLATE ASSY	NTS
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DATE	12.08.23		

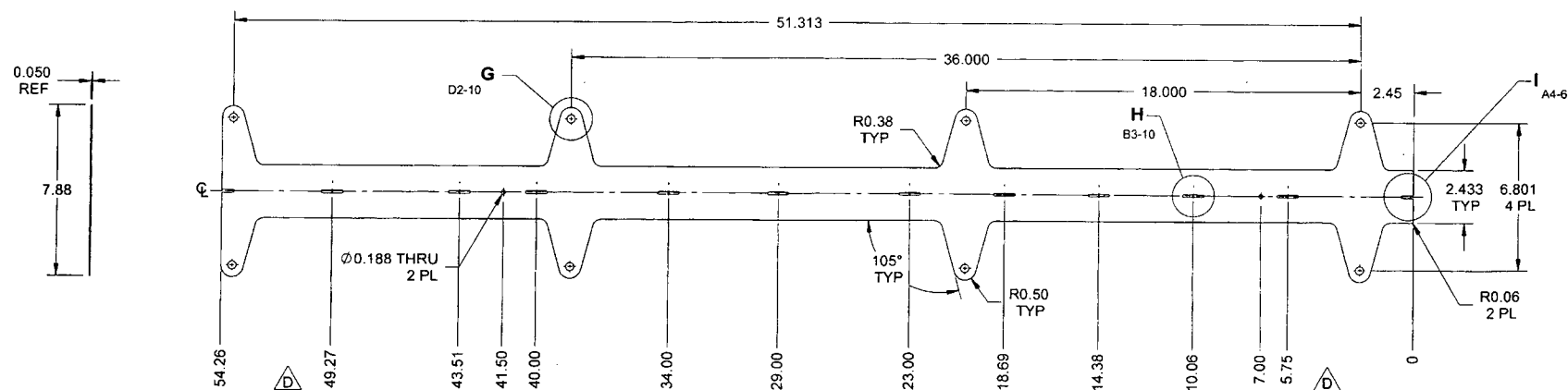
0.3 REF

R38.5

49.51

D6-10

D3849-7 PLATE
(MAKE FROM D3849-7F)



D3849-7F FLAT PATTERN

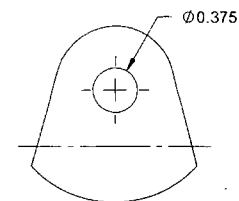
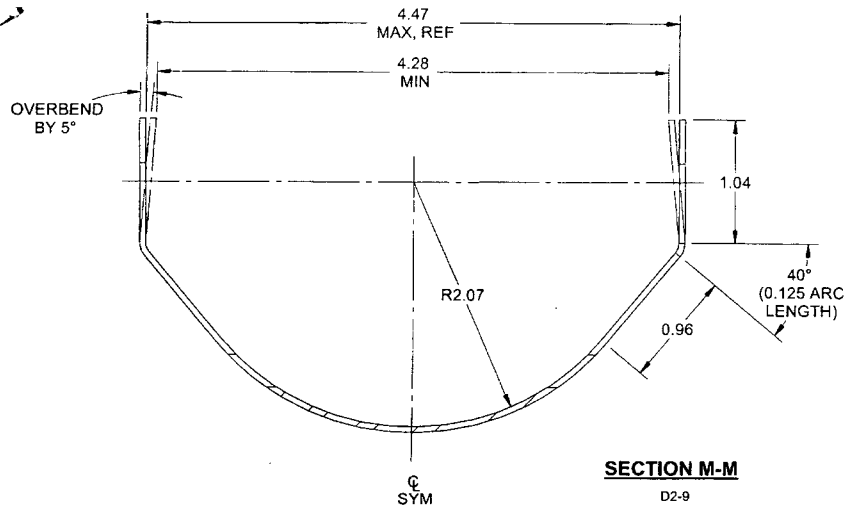
RELEASE
2012-09-04

NOTES:

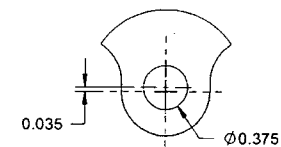
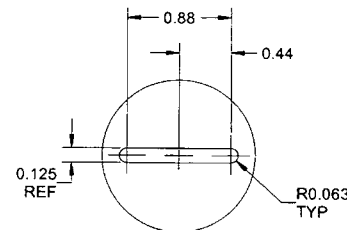
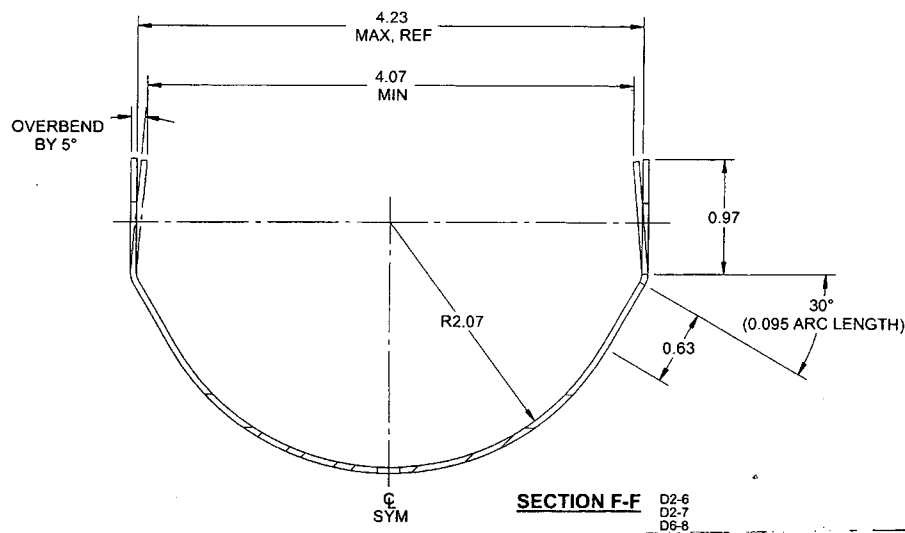
- NOTES:**
 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER AMS 5513 OR 5524
 OR ASTM A240 OR ASME SA240
 18 GAUGE 0.050 THICK, (REF. DART SPEC. M304S18GA)
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX.
 6) IDENTIFICATION: NONE
 7) WEIGHT: 2.32 lbs

DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	<i>BC</i>	KENT, WA	
CHECKED	<i>AS</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>AS</i>	D3849	SHEET 9 OF 10
APPROVED	<i>MA</i>	TITLE	SCALE
DE APPR.	<i>MA</i>	WEARPLATE ASSY	NTS
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90576



C4-6
C4-7
C4-8
C6-9



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DESIGN	RF	DART AEROSPACE USA, INC.	
DRAWN	BC	KENT, WA	
CHECKED	BC	DRAWING NO. D3849	REV. D
MFG. APPR.	BC	SHEET 10 OF 10	
APPROVED	BC	TITLE	SCALE
DE. APPR.	BC	WEARPLATE ASSY	NTS
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DART AEROSPACE LTD		Work Order: 90576
Description: Plate		Part Number: 08-03849-1
Inspection Dwg: 03849 Rev: 0		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 0.188"	+0.005" -0.001"	0.189"	-		✓	Vmm01
Ø 0.375"	+0.006" -0.001"	0.375"	-		✓	
0.125"	± 0.010"	0.127"	-		✓	
0.88"	± 0.030"	0.880"	✓		✓	
0.44"	± 0.030"	0.440"	-		✓	
51.313"	± 0.010"	51.313"	-		T	F1301
36.000"	± 0.010"	36.000"	-		T	
18.000"	± 0.010"	18.000"	-		T	
0.050"	± 0.010"	0.047"	-		✓	
7.72"	± 0.030"	7.726"	-		✓	
2.45"	± 0.030"	2.459"	-		✓	
2.433"	± 0.030"	2.435"	-		✓	
6.642"	± 0.030"	6.643"	-		✓	
5.75"	± 0.030"	5.753"	-		✓	
7.00"	± 0.030"	7.009"	-		✓	
10.06"	± 0.030"	10.057"	-		✓	
14.38"	± 0.030"	14.38"	-		T	
18.69"	± 0.030"	18.69"	-		T	
23.00"	± 0.030"	23.00"	-		T	
29.00"	± 0.030"	29.00"	-		T	
34.00"	± 0.030"	34.00"	-		T	
40.00"	± 0.030"	40.00"	-		T	
41.50"	± 0.030"	41.50"	-		T	

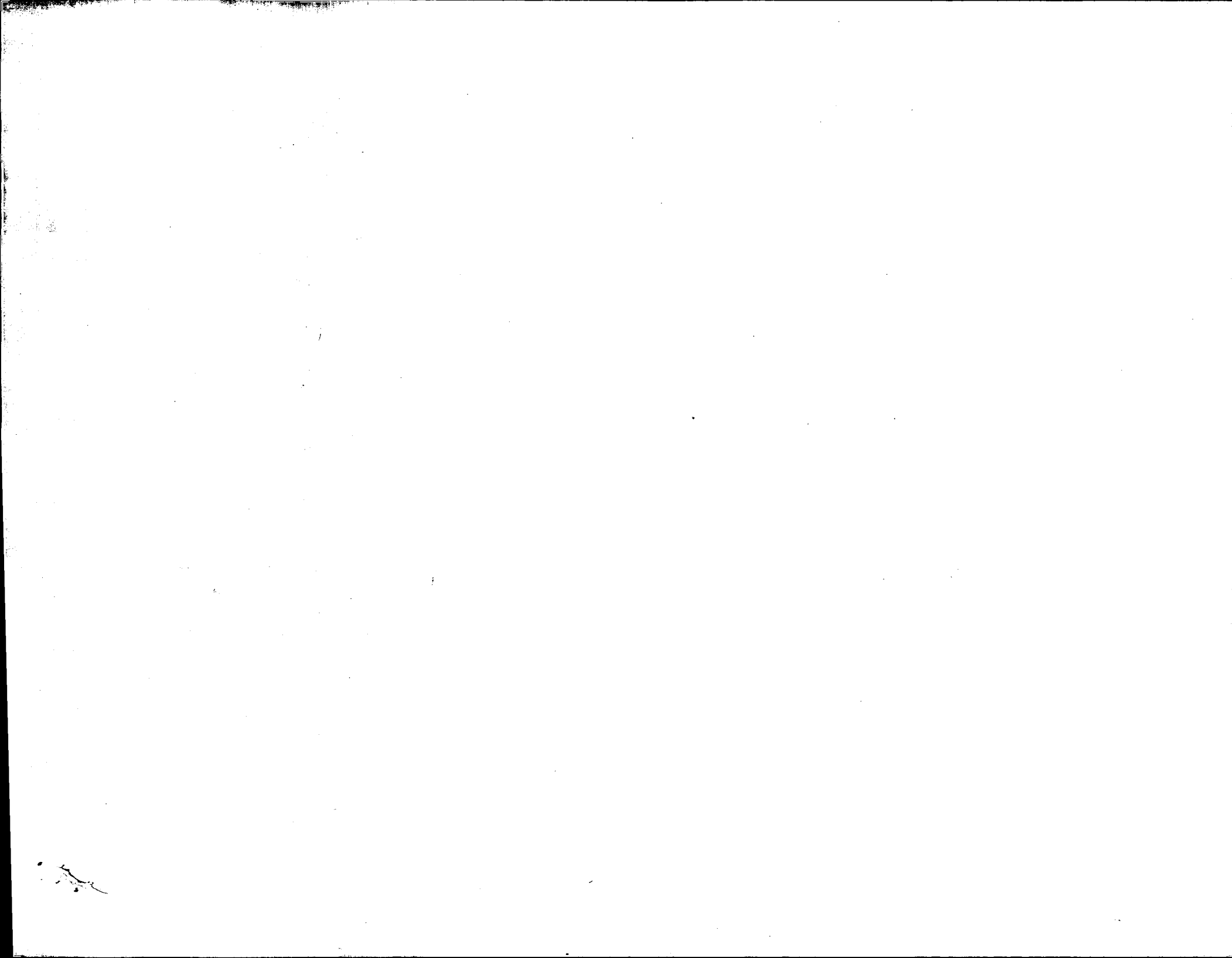
Measured by: JM
Date: 12-9-30

Audited by: 12-10-01
Date: SMR

Preliminary Approval:
Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15



FIRST ARTICLE INSPECTION CHECKLIST

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15

